

**Work Order ID 80582**

February-23-12 12:47:13 PM

**\*80582\***

Page 1

Item ID: D204-708-013

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Adjustable Engine Mount

Start Date: 2/23/12 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 2/23/12 Req'd Qty: 1.00 **\*1\***

Customer:

Reference: disassemble

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

IIN D204-708

Rev A

150

0.00

**\*150\***

Packaging

Packaging

Memo

0.00

Packaging

PULL FROM STOCK:

1 X D204-708-013 B56741

DISASSMEBLE KIT, RETURN ALL PARTS TO STK UNDER ORIGINAL  
B/N'S

6 X D3284-001 B24757

6 X D3284-005 B24757

6 X D3284-007 B24757

6 X D3284-009 B24775

1 X D3284-011 B24776

12 X MS20613-6C16 B *119397*12 X MS20613-6C19 B *60255*

6 X NAS509-12 B24757

6 X NAS509L12 B24757

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

*12/23/12**12/23/12**W 12/23/12*

# Picklist Print

February-23-12 12:47:19 PM

Page 1

Work Order ID: 80582

Parent Item: D204-708-013

Parent Item Name: Adjustable Engine Mount

Start Date: 2/23/12


Required Date: 2/23/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev C Added MS20613-6C12 Rivet JLM/AP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D204-708-013		Manufactured	No				Each	8.0000		1			
Adjustable Engine Mount													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG021		8							
				56741		8							
D3284-001		Manufactured	No				Each	2.0000					
Sleeve													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST036		2							
				59910		2							
D3284-005		Manufactured	No				Each	5.0000					
Stud													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST036		5							
				43645		3							
				79831		2							
D3284-007		Manufactured	No				Each	4.0000					
Stud													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST036		4							
				59048		2							
				79832		2							
D3284-009		Manufactured	No				Each	4.0000					
Bearing													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST036		4							
				79821		4							

  
 1  
 B24757  
 B24757  
 B24757  
 B24757  
 B24757  
 B24775

# Picklist Print

February-23-12 12:47:19 PM

Page 2

Work Order ID: 80582

Parent Item: D204-708-013

Start Date: 2/23/12

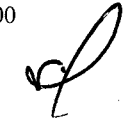
Required Date: 2/23/12

Parent Item Name: Adjustable Engine Mount

Start Qty: 1.00


Required Qty: 1.00

D3284-011      Manufactured      No      Each      5.0000  
Bearing

1324776 


<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST036	5	
60004	5	

MS20613-6C16      Purchased      No      Each      440.0000  
Rivet

m119-12 392 

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST322	440	
115358	440	

MS20613-6C19      Purchased      No      Each      0.0000  
Rivet


-12 m16255 

NAS509-12      Purchased      No      Each      42.0000  
Nut

-6 24757

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST279	42	
15057	42	

NAS509L12      Purchased      No      Each      38.0000  
Nut

-6 24757 

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST280	38	
102296	29	
15062	9	

February-23-12 12:47:19 PM

Shop Packet Print

Page 2

Date: Friday, 11/11/2005 3:22:46 PM  
User: Linda Lacelle

**Process Sheet**

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ADJUSTABLE ENGINE MOUNT KIT (204)
<b>Job Number</b> : 24757	
<b>Estimate Number</b> : 10102	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D204708013
<b>This Issue</b> : 11/11/2005 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : B807 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : <u>See comment below</u>	<b>Due Date</b> : 11/30/2005 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>See comment below</u>	
<b>Comment</b> : Est Rev:B 04.11.01 Assembly no longer made in-house KJ/JLM	

**Additional Product**

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL  
Photocopy bluefile & type labels per PPP204-708-013 CHG001

(12)

DT 06-01-11

2.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: 0000096 for:

- 6 D3284-001 Sleeve
- 6 D3284-005 Stud
- 6 D3284-007 Stud
- 6 NAS509-12 Nut
- 6 NAS509L12 Nut

h

05/11/14

to be assembled as per Dwg B80701 Rev. C Possible Supplier: Northern Aero Certificate of Conformity is required

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage  
Ensure Certificate of Conformity is attached

C206101109 10

Date: Friday, 11/11/2005 3:22:46 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ENGINE MOUNT KIT (204)

Job Number: 24757

Part Number: D204708013

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect assembly. Visually inspect thread, fit and cad plating

*LA 06-01-09*

5.0

D3284001

Sleeve



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit (Note: (1) D204-708-013 Kit includes all parts listed below)

Qty Part Number Description Batch

6 D3284-001 Sleeve *B24757*

6.0

D3284005

Stud



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit (Note: (1) D204-708-013 Kit includes all parts listed below)

Qty Part Number Description Batch

6 D3284-005 Stud *B24757*

7.0

D3284007

Stud



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit (Note: (1) D204-708-013 Kit includes all parts listed below)

Qty Part Number Description Batch

6 D3284-007 Stud *B24757*

8.0

D3284009

Bearing



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit (Note: (1) D204-708-013 Kit includes all parts listed below)

Qty Part Number Description Batch

6 D3284-009 Bearing *B24775-2 344p B24775 570p*

9.0

D3284011

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit (Note: (1) D204-708-013 Kit includes all parts listed below)

Qty Part Number Description Batch

1 D3284-011 Bearing *B24776-2 244p*

*B24776-2 844p*

Date: Friday, 11/11/2005 3:22:46 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ENGINE MOUNT KIT (204)

Job Number: 24757

Part Number: D204708013

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

MS206136C16

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit (Note: (1) D204-708-013 Kit includes all parts listed below)

Qty Part Number Description Batch  $\times 12$

12 MS20613-6C16Rivet M19096 ~~204mc~~

M19392 108mc

11.0

MS206136C19

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit (Note: (1) D204-708-013 Kit includes all parts listed below)

Qty Part Number Description Batch

12 MS20613-6C19Rivet M16255 62mc M19349 53mc

M15-921 5mc

12.0

NAS50912

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit (Note: (1) D204-708-013 Kit includes all parts listed below)

Qty Part Number Description Batch

6 NAS509-12 Nut B24757

13.0

NAS509L12

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit (Note: (1) D204-708-013 Kit includes all parts listed below)

Qty Part Number Description Batch

6 NAS509L12 Nut B24757

14.0

QC4

INSPECT 100% KITS FOR COMPLETENESS

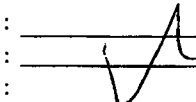
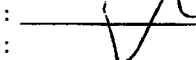


Comment: INSPECT 100% KITS FOR COMPLETENESS

C2061011 10

Date: Friday, 15/02/2008 9:48:54 AM  
User: Linda Lacelle

# Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D204-708-013
Job Number	: 37468		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D204708013
This Issue	: 15/02/2008 S.O. No. :	Drawing Number	: NCR274
Prsht Rev.	: NC	Project Number	:
First Issue	: 15/02/2008 Type : SMALL /MED FAB	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: 	Due Date	: 22/02/2008 Qty: 9 Um: Each
Checked & Approved By	: 		
Comment	:		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D204708013	Adjustable Engine Mount
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)  
Adjustable Engine Mount  
Pull from stock  
QTY: 9  
B24757

*208-02-15 9*

*chg 001*

2.0	PG	PURCHASING
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Comment: PURCHASING  
Have sleeves, B80702-1 original B24757, return for rework as per NCR 274.  
PIO: 5433

*208/02/15 9*

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Receive & Inspect For Transit Damage  
Ensure Certificate of Conformity & Process Sheet are attached

*208/02/15 9*

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

*208-02-15 9 kits*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per dwg.

*SAD 08/02/16*

# Work Order ID 56741

March 5, 2010 10:00:25 AM



Page 1

Item ID: D204-708-013

Revision ID:

Item Name: Adjustable Engine Mount

Start Date: 3-05-10 Start Qty: 9.00

Required Date: 3-05-10 Req'd Qty: 9.00

Reference:

Approvals:

Process Plan:

QC:

Sequence ID/  
Work Center ID

Draw Nbr

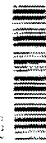
UIN D204-708

Rev A

Operation  
Description

Revision Nbr

120



Packaging

Packaging

Receive & inspect for Damage & Mfg Defects

Packaging

Memo

Pull from stock

9 x D204-708-013 (47368)

pull D284-007's from kit - return to Northern Aero for re-lead plating (see P 4)

11168 - was 56741

Return D284-007's to kit when returned from Northern Aero under UIN 56741

140



QC

Quantity Control

QC 140 - inspect kits for completeness

0.00

0.00

Memo

Accept



Setup



Start



Cust Item ID:

Customer:

Date:

Date:

Tooling:

SPC (Y/N):

Run



Start



Insp.

Stamp

Reject

Number

Plan

Code

Draw

Rev.

Set Up/

Run Hours

Accept

Qty

Reject

Qty

11410-3-12  
white boxed

Sub 12

Sub 12

100312